

# Work Order ID 71300

Monday, June 27, 2011 3:07:57 PM



Page 1

Item ID: D2965-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CMF Date: 11-06-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

100

0.00



CONVENTIONAL LATHE

0.00

Lathe Conv

Memo

Conventional Lathe

Turn as per Dwg D2965  
USE DT9536 PLUG

11/07/11

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

11/02/11

10

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

11/17/12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71300

Monday, June 27, 2011 3:07:57 PM



Page 2

Item ID: D2965-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Drill as per Dwg D2965 with DT8538 Debur and Tumble	0.00							
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Powdercoat	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____								
	FINISH TIME: _____								

M 117745 11:50 11:20 320 OF

10X 0 M 11/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71300

Monday, June 27, 2011 3:07:57 PM



Page 3

Item ID: D2965-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 0 M 11/07/12

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2965

10 0 M 11/07/12

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11 01 12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71300

Monday, June 27, 2011 3:07:57 PM



Page 4

Item ID: D2965-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: FP-5

0.00



Packaging

Memo

0.00

Packaging

10 0 91 11/07/12

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13 [Signature]

mf  
11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DESIGN	DRAWN BY		DART AEROSPACE USA, INC.	
014	014		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.		REV. B
		D2965		SHEET 1 OF 2
DATE	TITLE		SCALE	
06.11.01	CAP		1:2	
A	00.02.24		NEW ISSUE	
B	06.11.01		ADD -3 CAP	

1° TAPER

R0.50

R0.50

R1.80

0.188

0.125

2.25

Technical drawing of a semi-circular part with a central hole. The drawing shows a cross-section with a dashed line indicating the internal profile. Dimensions are given as 0.400 and 0.370.

# 71300

Technical drawing of a circular part with the following dimensions and tolerances:

- Top horizontal dimension: 0.405
- Top-left vertical dimension: 0.188 (upper), 0.125 (lower)
- Top-right radius: R0.50 (TYP)
- Right vertical dimension:  $\varnothing 3.330$  (upper), 3.300 (lower)
- Right-side vertical dimension: 0.188 (upper), 0.125 (lower)
- Left vertical dimension: 3.150 (upper), 3.120 (lower)
- Bottom-right angle: 45°

D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

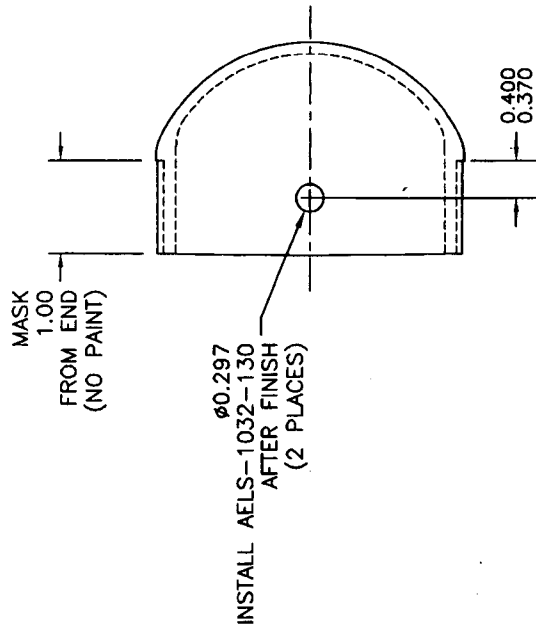
**NOTE:** Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2965	REV. B SHEET 2 OF 2
DATE 06.11.01		TITLE CAP	SCALE 1:2

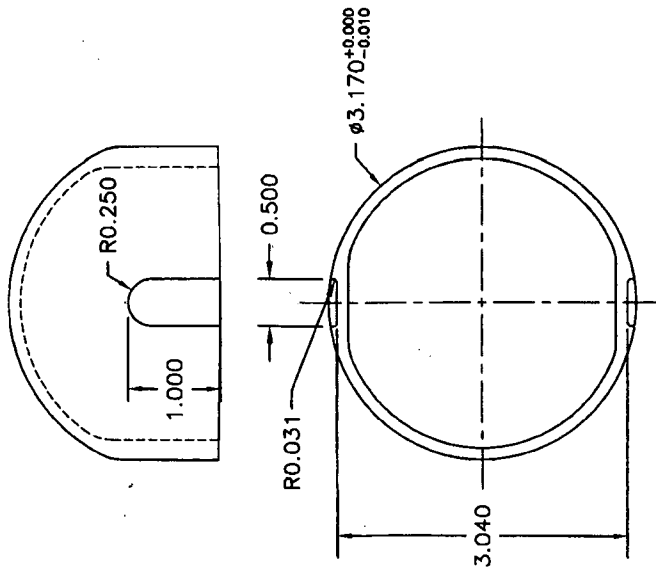
RELEASED

06.12.12



D2965-3 FINISH DETAIL

# 71300

D2965-3 CAP MACHINING DETAIL  
(MAKE FROM D2965 CAP)

- D2965-3 CAP
- 1) MATERIAL: MAKE FROM D2965 CAP
  - 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE INCHES

Copyright © 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries